

Work Order ID 152452

Monday, October 24, 2016 11:41:28 AM

152452

Page 1

Item ID: D4060-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ski Clamp, Top

Start Date: 10/19/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/24/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4060

C

100

0.00

100

Waterjet

Memo

0.33

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: CProg Rev: C

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.07

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.13

Quality Control

DAS
38
9-89

NOV 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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152452

Monday, October 24, 2016 11:41:28 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

40

Cust Item ID:

Start Date: 10/19/2016 **Start Qty:** 40.00

Required Date: 10/24/2016 **Req'd Qty:** 40.00

40

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 152452

Monday, October 24, 2016 11:41:28 AM

152452

Page 3

Item ID: D4060-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Ski Clamp, Top
Start Date: 10/19/2016 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 10/24/2016 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.67							
Quality Control									

DAS
21
9-89

NOV 8 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, October 24, 2016 11:41:28 AM

Page 1

Work Order ID: 152452

152452

Parent Item: D4060-1

D4060-1

Parent Item Name: Ski Clamp, Top

Start Date: 10/19/2016

Required Date: 10/24/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A new issue DD 10.02.16 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased				100	sf	41.0900	0.085	3.578948			

M304S14GA

304SS sheet .080

on 10/11/02

Location

Loc Qty

Loc Code

MAT019

41.09

M129972

5.7

M135061

1.29

M135689

2.4

M135860

31.7

4

DQA: _____ Date: _____



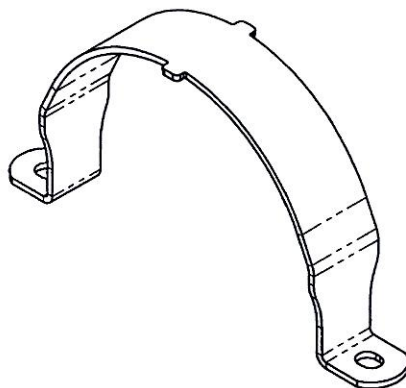
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

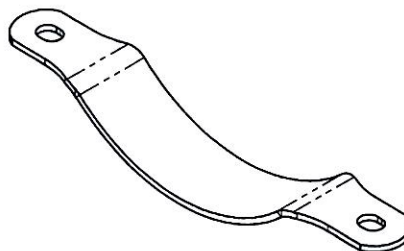
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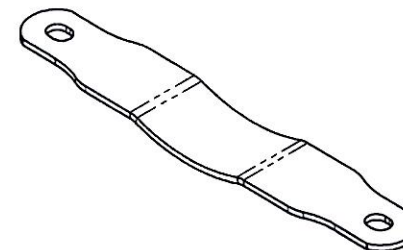
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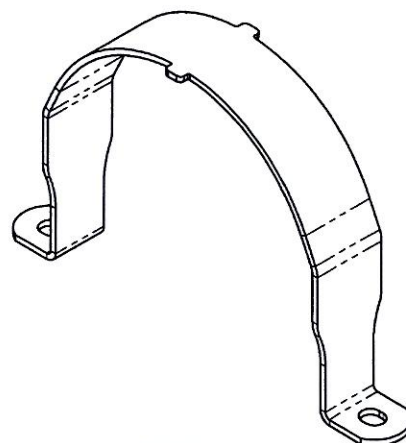
D4060-1 412 SKI CLAMP, TOP



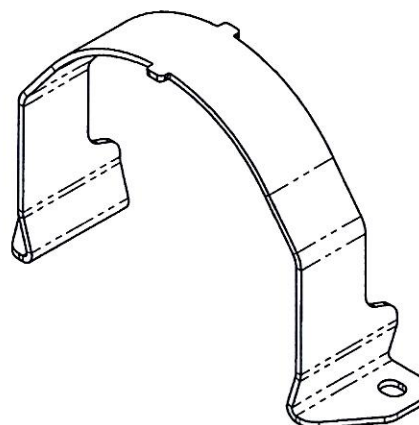
D4060-3 412 SKI CLAMP, BOTTOM



D4060-5 412 SKI CLAMP, AFT



D4060-7 BEARPAW CLAMP



D4060-9 AFT BEARPAW CLAMP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152452 ML5
16-10-24

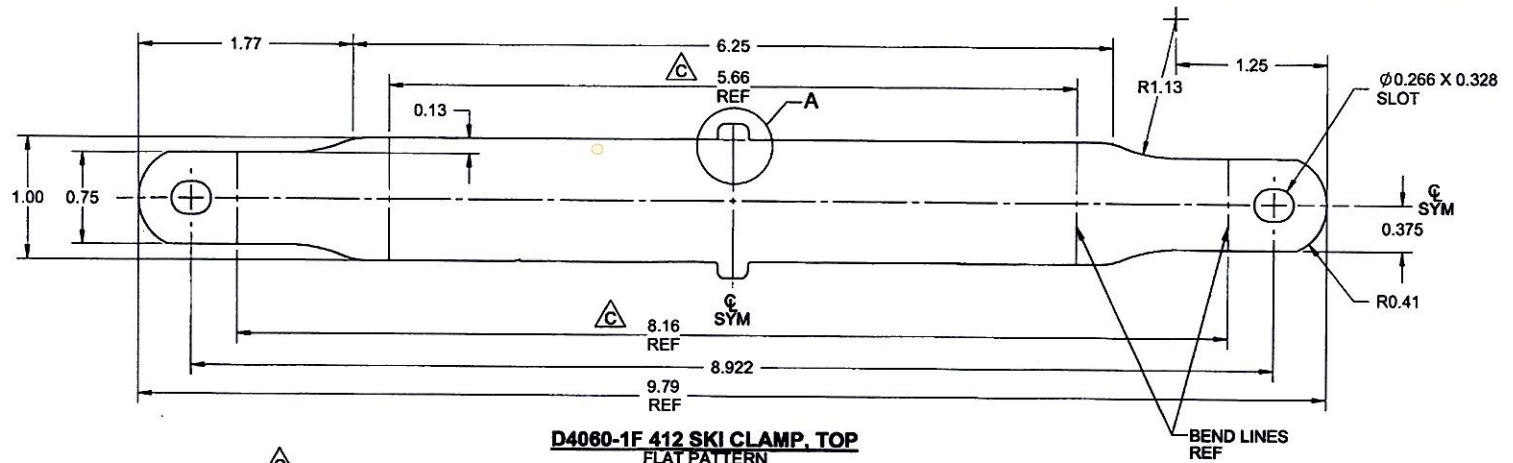
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: D4060-1/-7 = 0.23 lbs, D4060-3/-5 = 0.12 lbs, D4060-9 = 0.28

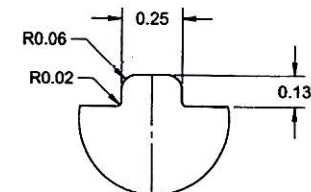
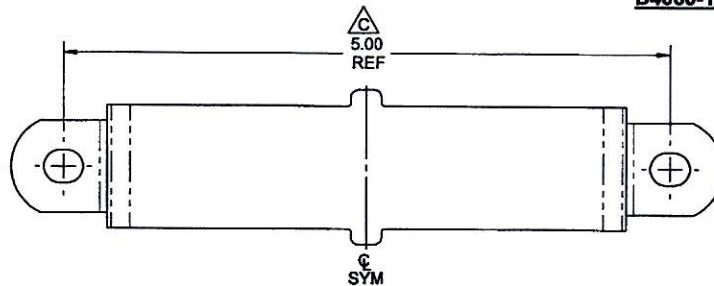
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2016-10-18
EN 16-154

APPROVED

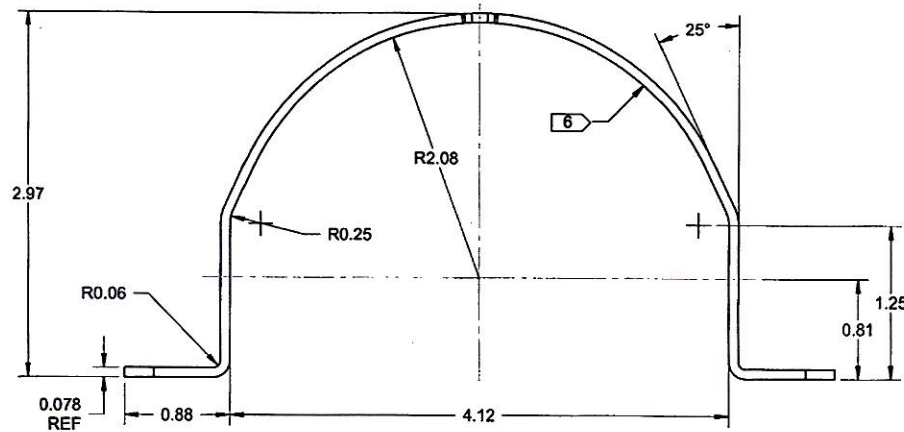
C	ADD -7 & -9. REASON: CIR16-67. ADD "REF" FOR BEND LINES.	AJS	16.05.09
B	ADD CUSHION RETENTION DETAILS TO -1 CLAMP. REASON: PAR 14-368, PAR 14-331, NCR 14-3521	VS	15.05.14
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 1 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
DATE	16.05.09	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D4060-1F 412 SKI CLAMP, TOP
FLAT PATTERN**



**DETAIL A
SCALE 2X
2 PL**

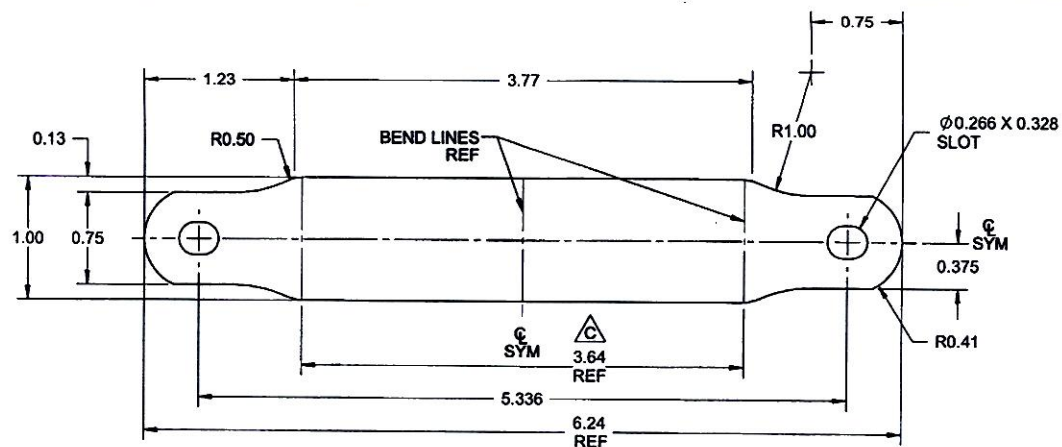


**D4060-1 412 SKI CLAMP, TOP
MAKE FROM D4060-1F**

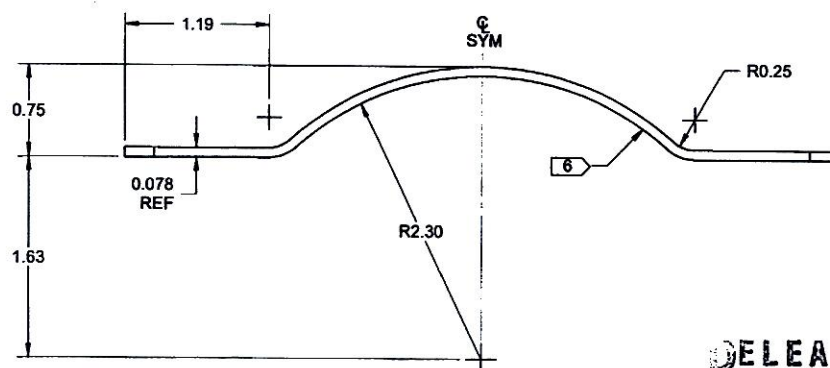
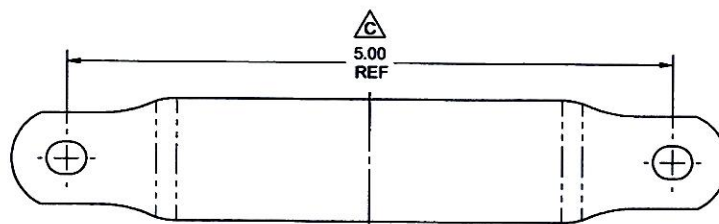
RELEASED
2016-10-18

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DESIGN	VS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 2 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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**D4060-3F 412 SKI CLAMP, BOTTOM
FLAT PATTERN**



**D4060-3 412 SKI CLAMP, BOTTOM
MAKE FROM D4060-3F**

RELEASED
2016-10-18

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 3 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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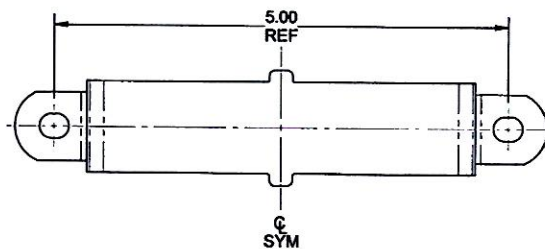
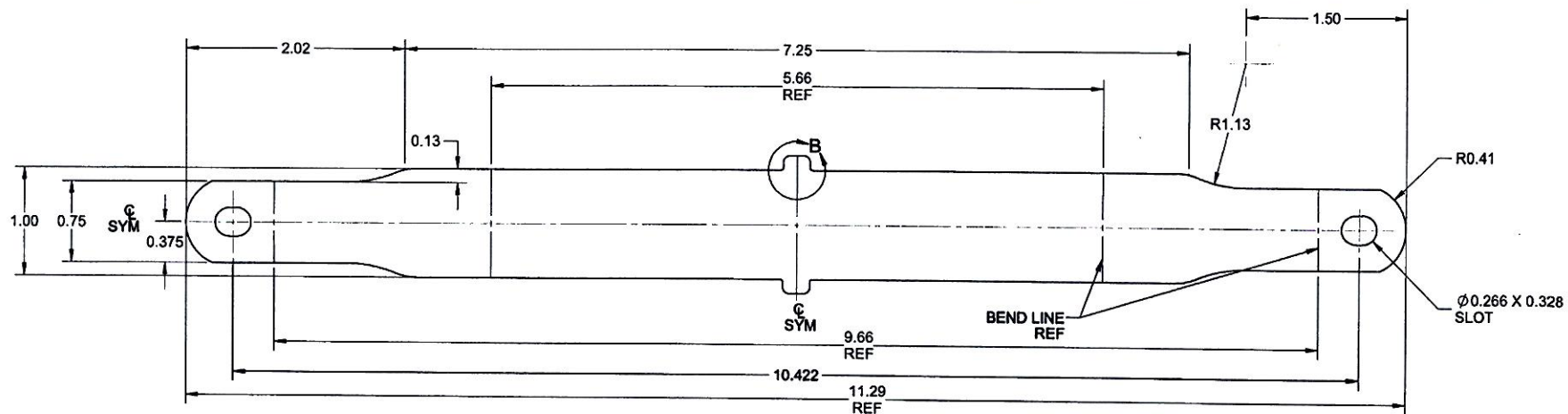
D4060-5 412 SKI CLAMP, AFT
MAKE FROM D4060-5F

D4060-5F 412 SKI CLAMP, AFT
FLAT PATTERN

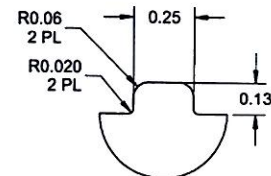
RELEASE
2016-10-18

APPROVED

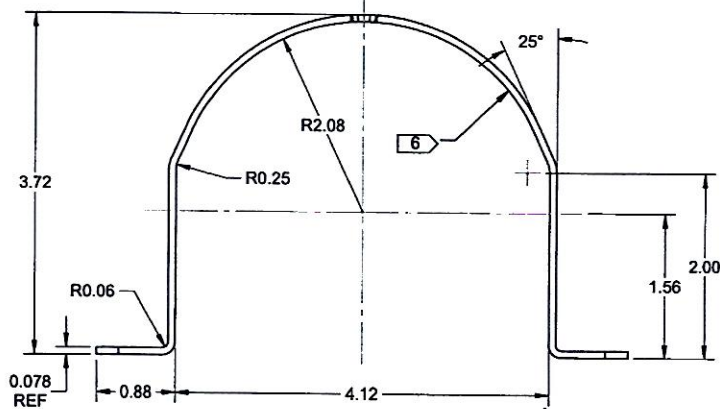
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DL	DRAWING NO.	REV. C
MFG. APPR.	MD	D4060	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NT
DATE	16.05.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED IN ANY OTHER MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4060-7F BEARPAW CLAMP
FLAT PATTERN



DETAIL B
SCALE 2X
2 PL



D4060-7 BEARPAW CLAMP
MAKE FROM D4060-7F

RELEASED
2016-10-18

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 5 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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